

**Work Order ID 60192**

Monday, June 28, 2010 3:18:46 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 6/28/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

*PR*

Date: 16-6-29 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

*304.063*

Memo

0.00

*PR 16-6-30*1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr  
if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

*PR 16-6-30*

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

*16-07-01**cont'd**(X48)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3537-1

Revision ID:

Item Name: Wearpad

Start Date: 6/28/2010 Start Qty: 40.00

Required Date: 7/5/2010 Req'd Qty: 40.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Brake NC

NC BRAKE

0.00

Brake NC

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-  
Identify as D3537-1

0.00

140



Large Fab

0.00

Large Fab

Memo

Qty Description Batch □ A/R 2059B Hardcoat  
M 114 S18 □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any  
weld that penetrated through Wearpadif necessary

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

S. Wesley

Counter

X48

10-8-4  
ER ~~10-8-4~~ X48

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Wearpad

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Start Date: 6/28/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S10108104

  
X48
  
Locuton

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/12/2010

Memo

0.00

START TIME:

11:00

OVEN TEMPERATURE:

320

FINISH TIME:

11:30

48 BR 10-8-5.

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

  
M 10 08 05 48

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, June 28, 2010 3:18:46 PM



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Item ID: D3537-1

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Item Name: Wearpad

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Start Date: 6/28/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Packaging

Packaging

Identify as per dwg &amp; Stock Locations

FP-17

0.00

48

BL108-4

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/08/05 AF

MF

10-8-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, June 28, 2010 3:18:53 PM

Page 1

Work Order ID: 60192



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	77.3439	0.106	4.463158	 (810 - 6 - 3)		5.6

Location	Loc Qty	Loc Code
MAT	77.34389474	
111323	0	
114799	77.3438947	114799

(48)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60192
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>R</u>	Audited by: <u>J</u>	Prototype Approval: N/A
Date: 10-6-31	Date: 10/07/01	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

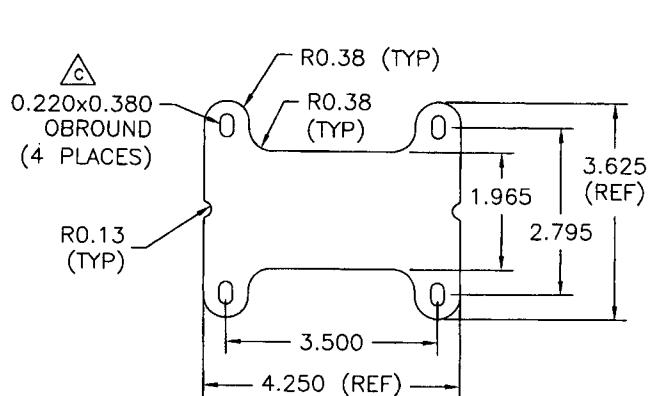
SHOP  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

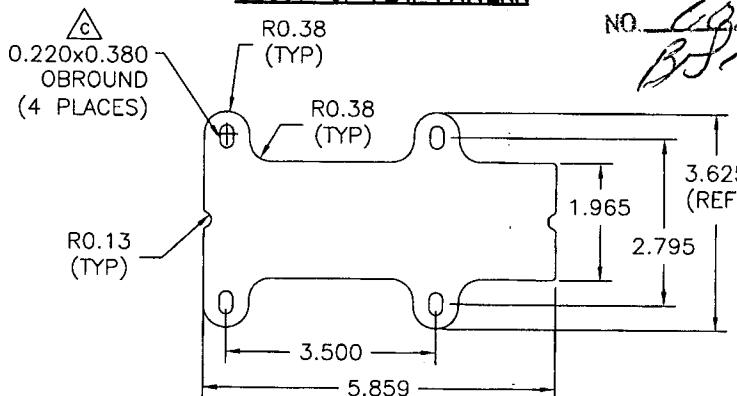
WITHOUT NOTICE  
WORK ORDER

NO. CG192  
B810-629

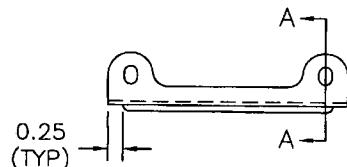
D3537-1F FLAT PATTERN



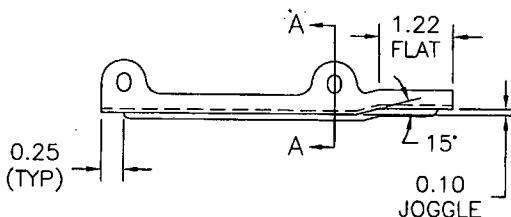
D3537-3F FLAT PATTERN



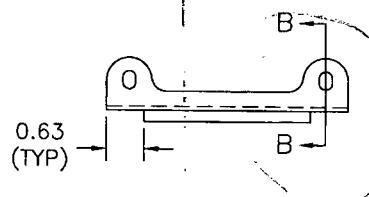
D3537-1 LONGITUDINAL BEND  
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



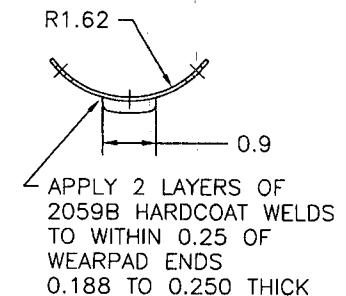
D3537-5 LONGITUDINAL BEND  
(MADE FROM D3537-1F)



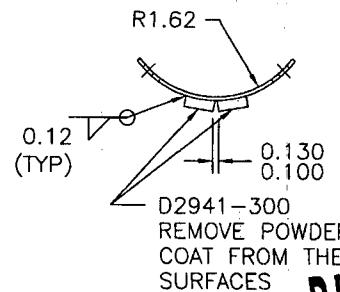
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A

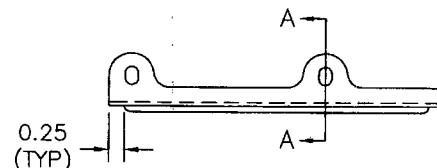


SECTION B-B



RELEASED  
07.05.08 A4  
per ELN

D3537-7 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537 REV. C SHEET 1 OF 1
DATE	07.04.13	TITLE WEARPAD SCALE 1:2

W/O:		WORK ORDER CHANGES						
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